

Date: Monday, 2/19/2007 8:07:20 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	PLATE
Job Number	30744		
Estimate Number	12669		
P.O. Number	10A	Part Number	D323833
This Issue	2/19/2007	S.O. No.	10A
Prsht Rev.	NC	Drawing Number	D3238 REV B
First Issue	N/A	Project Number	N/A
Previous Run	30688	Drawing Revision	B
Written By	<u>JLM</u>	Material	N/A
Checked & Approved By	<u>JLM 07-02-19</u>	Due Date	2/26/2007
Comment	Est Rev:A New Issue 07-01-26 JLM	Qty:	16
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S020	6061-T6 .020 Sheet
Comment: Qty.: 0.0252 sf(s)/Unit Total : 0.4032 sf(s) 6061-T6 .020 Sheet X → Batch: <u>M 4894</u> 5052 - 0.20		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3238 Dwg Rev: <u>B</u> ml 07 02 20 (16) Prog Rev: <u>B</u>		
2-Deburr if necessary ***Use cutting file D3238-21-23-25*****		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		ml 07 02 20 (16)
Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAV 07/02/19 (16) PTB		
4.0	QC8	SECOND CHECK
		JLM 07 02 20 (16)
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		(16)
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 4/8/2019 07-02-20 (16)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/19	2.0	the orifice had to be change so 2 piece were Scrap	<input checked="" type="checkbox"/> QS1042	Scrap & destroy replace	SAD 07/02/19	<input checked="" type="checkbox"/> 07/02/19	<input checked="" type="checkbox"/> QS1042	<input checked="" type="checkbox"/> 07/02/19
07/02/19	2.0	Scrap 16 parts holes were out of tolerance program error	<input checked="" type="checkbox"/> 07/02/22 QS1042	Scrap & destroy	SAD 07/02/19	<input checked="" type="checkbox"/> 07/02/22	<input checked="" type="checkbox"/> QS1042	<input checked="" type="checkbox"/> 07/02/22

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 30744

Part Number: D323833

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/21 (16)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

T C 7/21 (16)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(16)

Comment: FINAL INSPECTION/W/O RELEASE

A 7/10/20

Job Completion



W 7/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

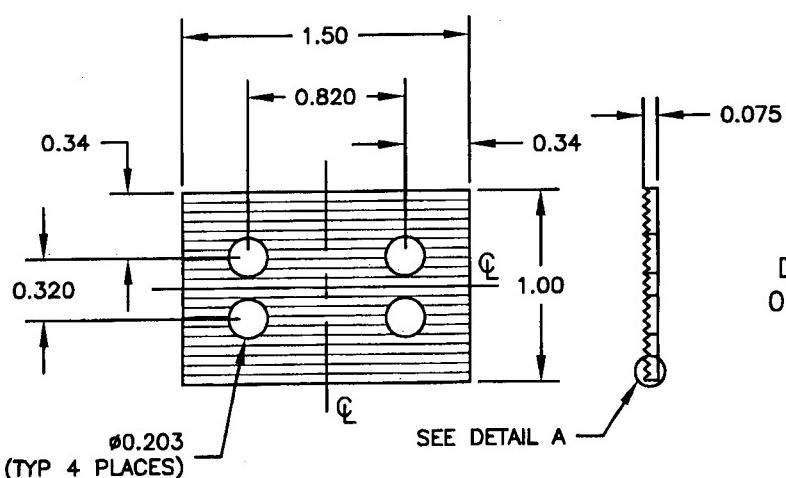
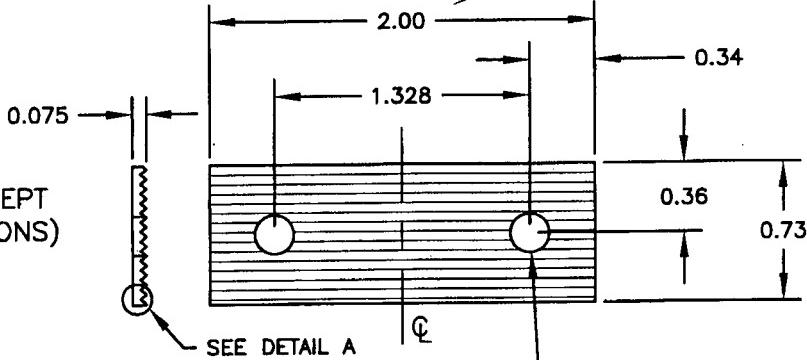
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

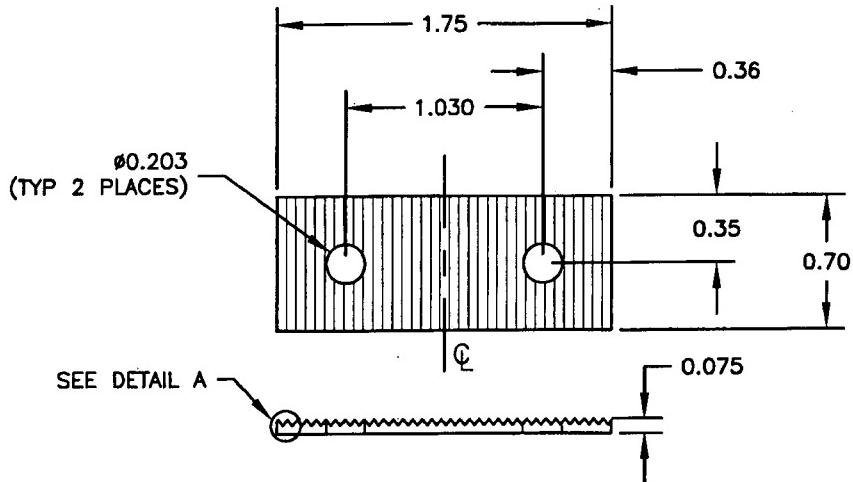
DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TA</i>	DRAWING NO. D3238	REV. B SHEET 1 OF 3
DATE 07.01.17		TITLE PLATE	SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	

**RELEASED**07.01.22 *[Signature]***NOTES:**

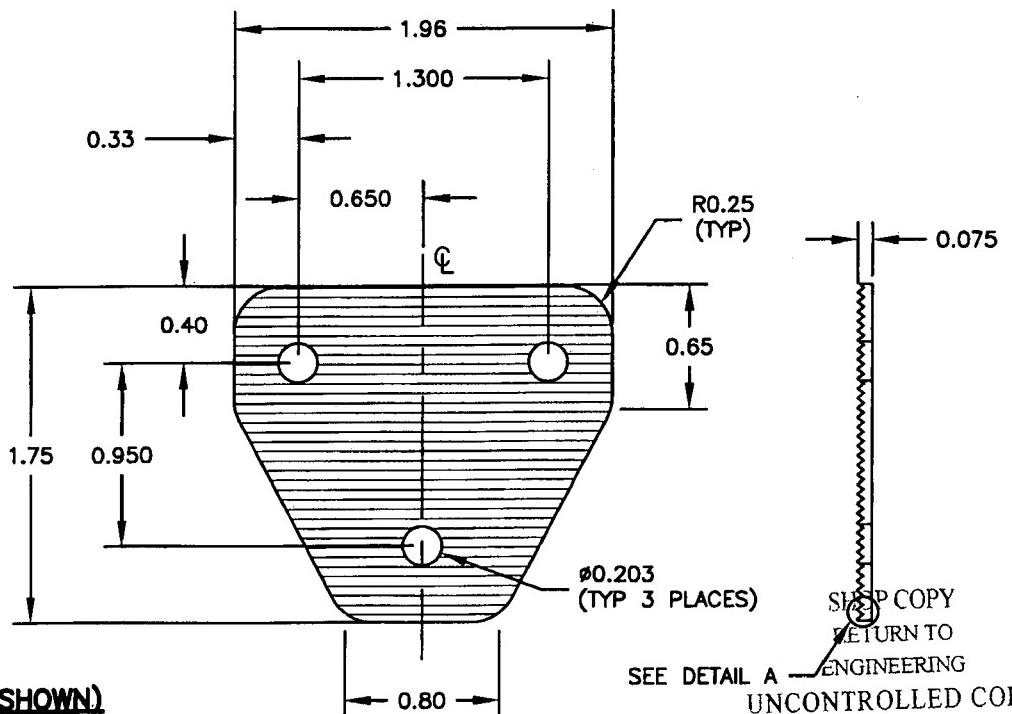
- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
 - 11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/1P1 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020) RETURN TO
ENGINEERING
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 004 4.1
 - 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) SEE SHEET 3 FOR DETAIL A
 - 7) PARTS ARE SYMMETRIC ABOUT $\frac{1}{4}$
- UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30744*

DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3238	REV. B SHEET 2 OF 3
DATE 07.01.17		TITLE PLATE	SCALE 1:1



D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

RELEASED07.9.22 *[Signature]*

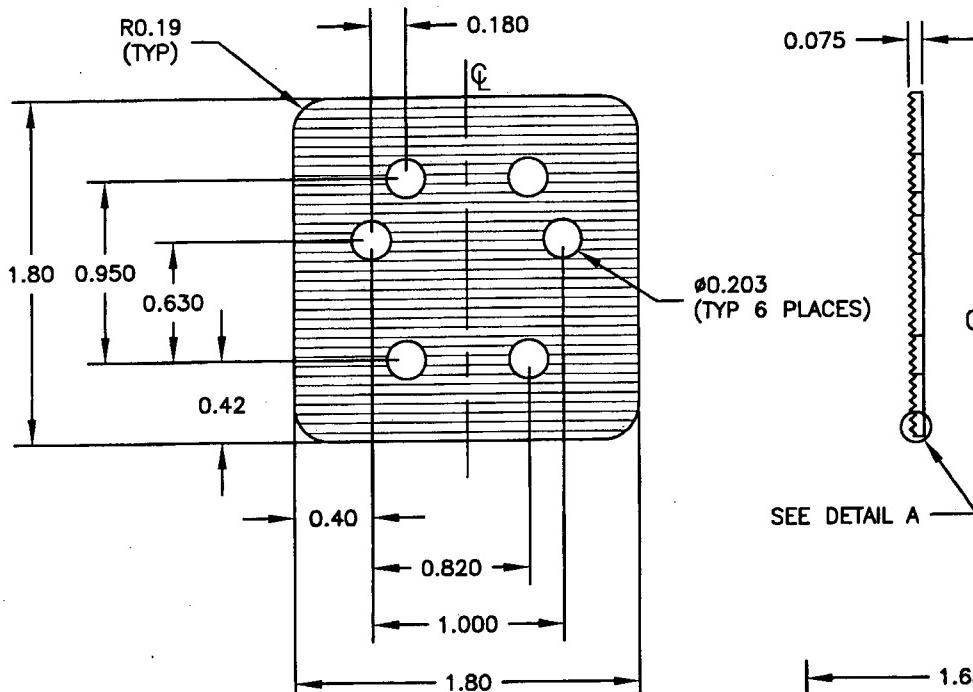
D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

SEE DETAIL A — UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30744*

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3238
DATE		TITLE PLATE

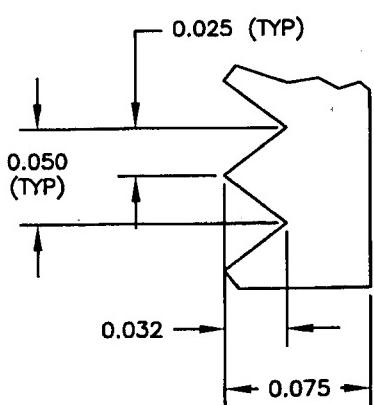
REV. B
SHEET 3 OF 3
SCALE
1:1



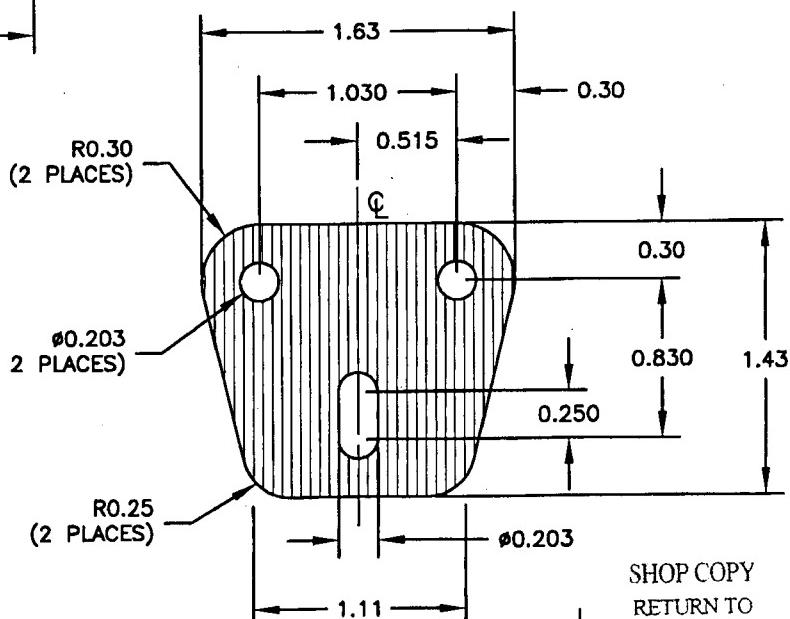
RELEASED

07.01.22 *[Signature]*

D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



DETAIL A
RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30744*

D3238-25 PLATE (SHOWN)
D3238-35 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

DART AEROSPACE LTD

Work Order: 30744

Description:

Part Number: D3238 33

Inspection Dwg:

, Rev:

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:

SAN

Date: 28/02/2019

Audited by:

23

Date: 02/02/19

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	30744
Description: PLATE	Part Number:	D3238-33
Inspection Dwg:D3238 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	M. M.
Date:	07-02-20

Audited by:	
Date:	

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	